

Work Order ID 133687

Tuesday, June 16, 2015 10:35:01 AM

133687

Page 1

Item ID: PB67-43001-51 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Long T-Handle Assembly
 Start Date: 6/16/2015 Start Qty: 3.00 *3* Cust Item ID:
 Required Date: 6/16/2015 Req'd Qty: 3.00 *3* Customer:
 Reference:

Approvals: Process Plan: ML3 Date: JUN 16 2015 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
B67-43001-51	C								
100	Weld per dwg A/R Aluminum rod Batch: _____ Large Fab	0.00							
100									
Large Fab	Memo	0.00							
Large Fab	1- drill #40 hole in center of -91 before welding -93 caps, to let air out 2- weld -93 to -91 as per dwg 3- grind weld flush 4- assemble -87 under the pilot hole in -91 and weld as per dwg								
						DAS 43 9-89	3x		JUL 20 2015
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110									
QC	Memo	0.00							
Quality Control									
						3			JUL 20 2015
							DAS 24 9-89		
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									
						3			JUL 20 2015
							DAS 24 9-89		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

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Page 2

Item ID: PB67-43001-51

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Long T-Handle Assembly

Stop ***NS2***

Start Date: 6/16/2015 Start Qty: 3.00

3

Cust Item ID:

Required Date: 6/16/2015 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept Reject Reject Insp.
Qty Qty Number Stamp

130

130

Small Fab

Small Fab

Memo

0.00

DAS
43
9-89

3x JUL 20 2015

Small Fab

1- line drill -89 and -87 using existing pilot hole of -87 as per dwg
2- install spring pin

140

140

QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

DAS
24
9-89

3 JUL 20 2015

Quality Control

150

150

Powdercoat

Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

0.00

M 111277

Memo

0.00

Powder Coating

mask prior to powder coat per dwg
START TIME: 1:10
OVEN TEMPERATURE: 320°
FINISH TIME: 1:40

3 15-7-23 DAS 34 9-89

DQA: _____ Date: _____



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Page 3

Item ID: PB67-43001-51

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Long T-Handle Assembly

Stop ***NS2***

Start Date: 6/16/2015 Start Qty: 3.00

3

Cust Item ID:

Required Date: 6/16/2015 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									

38
JUL 8 2015

170 Identify as per dwg & Stock Location: M6722 0.00

170
Packaging Memo 0.00
Packaging

③ JA ^{DAS} 27 ₉₋₂₉ JUL 29 2015

180 QC21- Final Inspection - Work Order Release 0.00

180
QC Memo 0.00
Quality Control

15/1/30

Sho 20150730

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Tuesday, June 16, 2015 10:35:04 AM

Page 1

Work Order ID: 133687

133687

Parent Item: PB67-43001-51

PR67-43001-51

Parent Item Name: Long T-Handle Assembly

Start Date: 6/16/2015

Required Date: 6/16/2015

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A 08-07-25 new issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

PB67-43001-87

Manufactured

No

100

Each

0.0000

1

3

PR67-43001-87

Tube Arm

**

133687 x3

PB67-43001-91

Manufactured

No

100

Each

1.0000

1

3

PR67-43001-91

Tube Handle

**

MF 15-7-16

Location

Loc Qty

Loc Code

Mezz2

1

133692 x3

113399

1

PB67-43001-93

Manufactured

No

100

Each

6.0000

2

6

PR67-43001-93

Tube End Cap

**

Location

Loc Qty

Loc Code

Mezz2

6

MF 15-7-15

113400

6

240-107

Purchased

No

130

Each

176.0000

1

3

240-107

SPRING SLOTTED PIN

**

DAS
43
9-89

JUL 20 2015

Location

Loc Qty

Loc Code

ST568

176

3x

m132006

176

PB67-43001-89

Manufactured

No

130

Each

6.0000

1

3

PR67-43001-89

Clevis

**

Location

Loc Qty

Loc Code

Mezz2

6

133544

6

MF 15-7-15

x3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

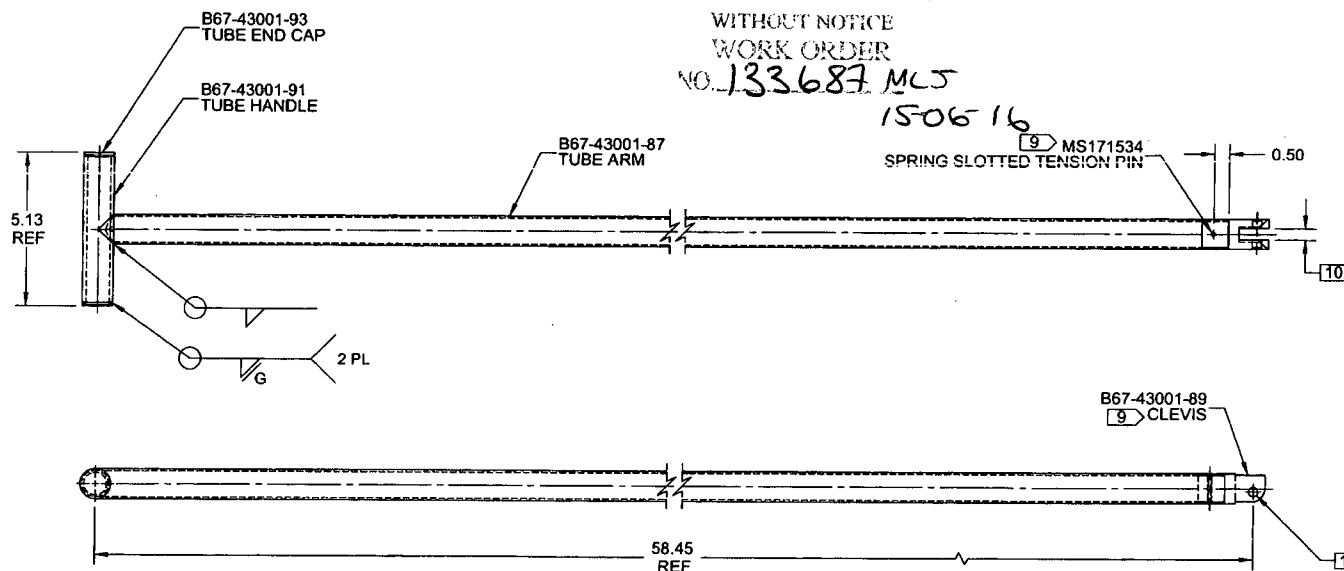
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐															
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval													
Description Work Order Deviation			Disposition														
			Completed By														
			Lead hand / Supervisor Approval Verification														
			QC / QA Coordinator Approval														
Root Cause		FAULT CATEGORY															
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐				Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐				Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐				Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____																	

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SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 133687 MJS
15-06-16

ITEM	QTY -19	P/N	DESCRIPTION
1	X	B67-43001-51	LONG T-HANDLE ASSY
3	1	B67-43001-87	TUBE ARM
4	1	B67-43001-89	CLEVIS
5	1	B67-43001-91	TUBE HANDLE
6	2	B67-43001-93	TUBE END CAP
8	1	MS171534	SPRING SLOTTED TENSION PIN (OR 240107)



B67-43001-51 LONG T-HANDLE ASSY

RELEASED
2009-09-24

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.35 lbs
- 8) WELDING: PER QSI 004
- 9) PRIOR TO POWDER COAT, ALIGN B67-43001-89 ON B67-43001-87 AS SHOWN AND DRILL A $\varnothing 0.129$ HOLE THROUGH BOTH PARTS AND FASTEN B67-43001-89 TO B67-43001-87 USING MS171534 SPRING SLOTTED PIN
- 10) MASK PRIOR TO POWDER COAT

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 13 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.	MB	09.06.25
REV.	DESCRIPTION	BY	DATE
DESIGN	RW		
DRAWN			
CHECKED	ADS		
MFG. APPR.			
APPROVED	ADS		
DE APPR.	N/A		
DATE	09.06.25		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. B67-43001-51
REV. C
SHEET 1 OF 1
TITLE LONG T-HANDLE ASSY
SCALE NTS
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THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD